

Work Order ID 85346

85346

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Wednesday, June 06, 2012 3:46:28 PM

Item ID: D3914-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 6/6/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/19/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 12-06-06 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	B								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 4118/61 0.00
 Large Fab
100
 Large Fab
 Large Fab
 Memo 0.00
 1- assemble ribs, weld as per dwg D3914 using DT9607A ✓
 2- weld hinge (3) and Mounting brackets as per dwg D3914 ✓
 Visual inspect before welding mesh ✓
 3- tack weld mesh on basket as per dwg D3914 ✓
 Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh ✓

1x 12.06.13

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110
 QC Memo 0.00
 Quality Control

1x 12.06.13

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120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

0.00

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

0.00

*** mask sides of hinge prior to powdercoat***

Start Time: 3:40

Oven Temperature: 3200 F

Finish Time: 4:10

140

Wing Walk as per dwg QSI005 4.4 Batch 1216B 0.00

140

HandFinish

Hand Finishing

Memo

0.00

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label

M121279

8/2/12/13

1x 12.06.13

1x 12/6/13

1 12.6.12

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150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

160	Identify as per dwg & Stock Location: <u>D4030-04.00</u> <u>85344.</u>								
160									
Packaging	Memo	0.00							
Packaging									

170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCJ 12/06/15

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Picklist Print

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Work Order ID: 85346

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/6/2012

Required Date: 6/19/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
10.08.18 verified by:EC

IPP Rev:B as per dwg revB DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D2581 Mounting Bracket		Manufactured	No			100	Each	53.0000	2	2		12.06.12	

Location	Loc Qty	Loc Code
WA	10	
82506	2	
83230	8	
WA005	43	
70766	2	
81253	1	
82897	40	

✓ D3914-1 Rib		Manufactured	No			100	Each	8.0000	2	2		12.06.12	
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Location	Loc Qty	Loc Code
WA	6	
85293	6	
WA006	2	
81449	1	
82131	1	

* D3914-7 Rib		Manufactured	No			100	Each	10.0000	2	2		12.06.12	
------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	----------	--

Location	Loc Qty	Loc Code
WA	1	
81209	1	
85294	6	
WA006	9	
82928	3	

W/O:		WORK ORDER CHANGES					
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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 6/6/2012

Required Date: 6/19/2012

Start Qty: 1.00

Required Qty: 1.00

✓ D4016-3	Manufactured	No	100	Each	22.0000	3	3	<u>12.06.12</u>
Hinge Half, Lid								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	22				
			83680	4				
			84777	18		3x		
✓ D4018-5	Manufactured	No	100	Each	46.0000	9	9	<u>12.06.12</u>
Rib								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	45				
			81178	45		9x		
			WA005	1				
			80776	1				
✓ D4020-5	Manufactured	No	100	Each	1.0000	1	1	<u>12.06.12</u>
Mesh (350 Basket Long, Lid)						385352		
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	1				
			84898	1				
✓ D4021-3	Manufactured	No	100	Each	11.0000	1	1	<u>12.06.12</u>
Data Plate						385358	1x	
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	11				
			80897	9				
			82507	1				
			82755	1				
✓ D4035-041	Manufactured	No	100	Each	18.0000	1	1	<u>12.06.12</u>
Lid Rib Assembly, Fwd (350 Basket)								
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>			
			WA	18				
			63720	0				
			82985	5				
			82986	13		1x		

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Parent Item: D3914-041

Start Date: 6/6/2012

Required Date: 6/19/2012

Parent Item Name: Long Basket Lid Assembly (350)

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-043

Manufactured No

100 Each 4.0000

Lid Rib Assembly, Aft (350 Basket)

~~382988~~ → 1 12.06.12

Location

Loc Qty

Loc Code

WA

3

81452

1

82987

2

WA006

1

81202

1

D2728-3

Manufactured No

140 Each 0.0000

Dart Logo label

1 1 12.6.14.

115050.

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

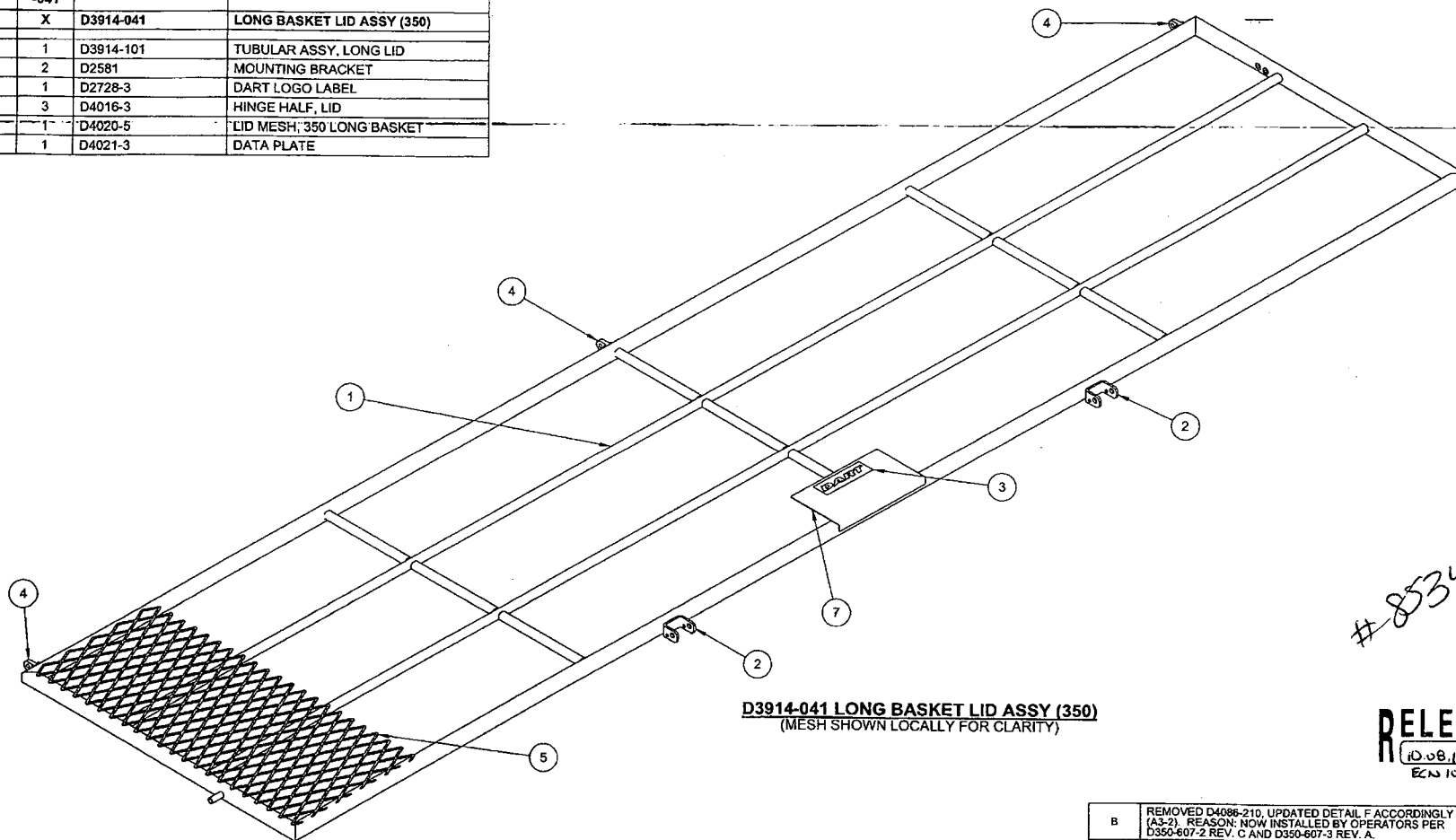
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

#85346

RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) SCALE NTS SHEET 1 OF 4 REV. B COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

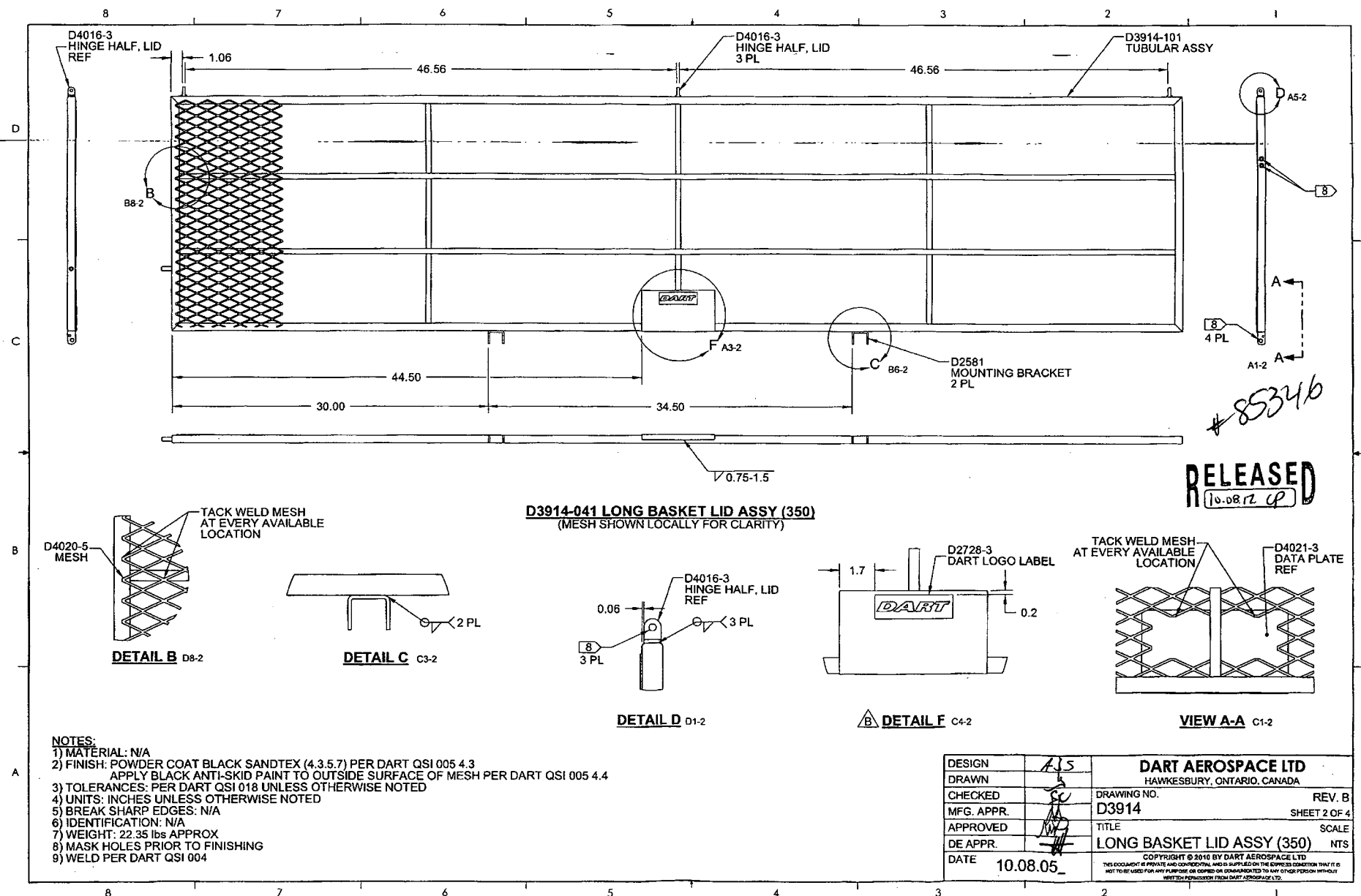
Dart Aerospace Ltd

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DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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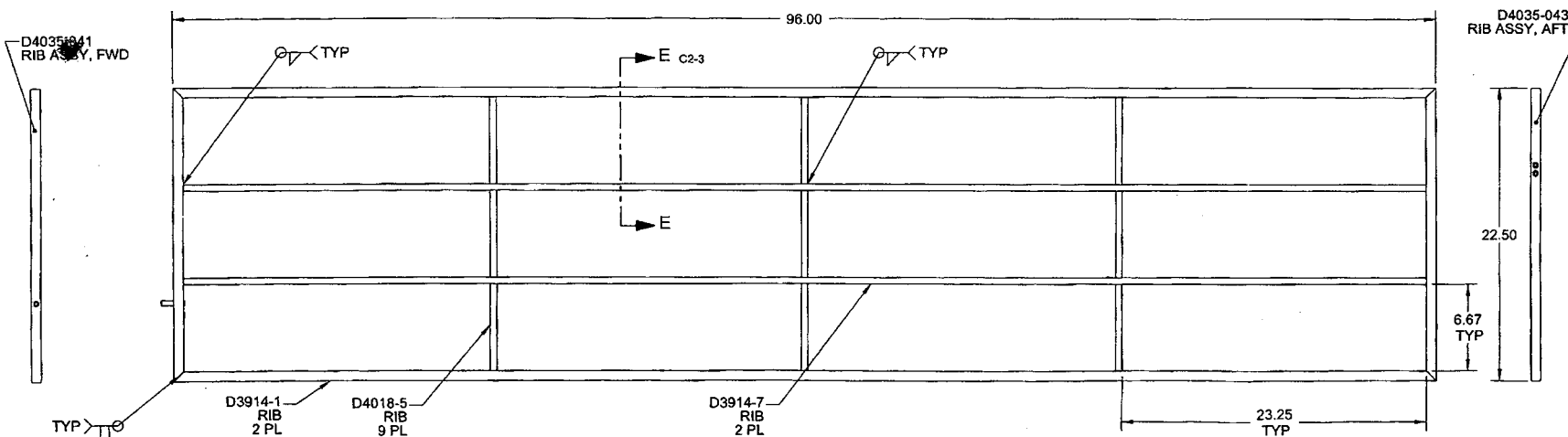
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

5346



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	MD	D3914	SHEET 3 OF 4
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DE APPR.	MD	LONG BASKET LID ASSY (350)	NTS
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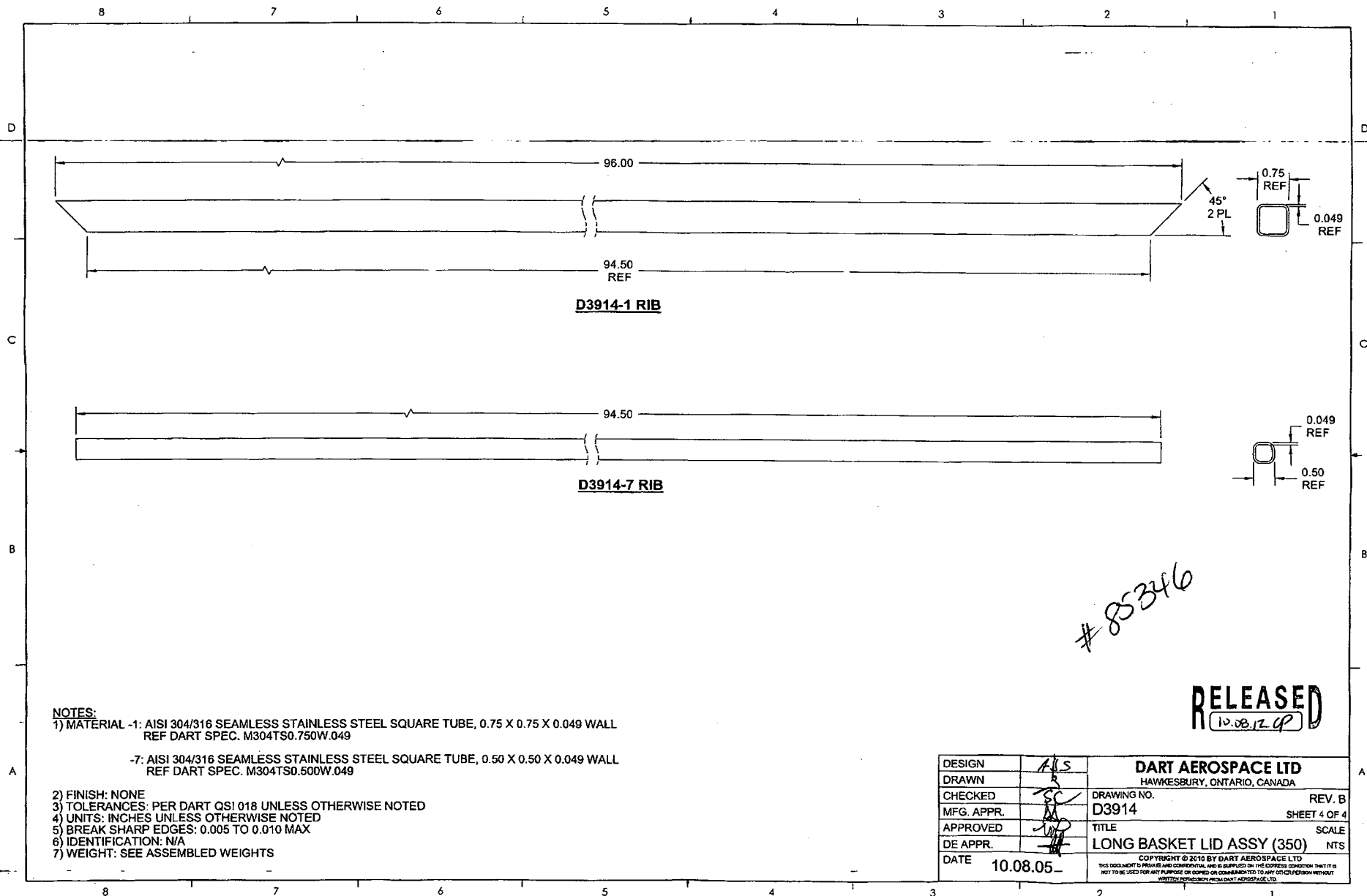
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